







Date: Monday, 26/01/2009 11:45:59 AM  
 \*User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B
Job Number	: 45234A		
Estimate Number	: 10163		
P.O. Number	:	Part Number	: D206642241
This Issue	: 26/01/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2650 REV F
First Issue	: //	Project Number	: N/A
Previous Run	: 45233A	Drawing Revision	: F
Written By	:	Material	:
Checked & Approved By	: <u>JUL. 29.01.2009</u>	Due Date	: 13/02/2009
Comment	: Est Rev:M 04.12.02 Revised procedural steps KJ/JLM	Qty:	1 Um: Each
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
			
Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D206-642-241 CHG003 N/A <i>[Signature]</i>			
2.0	D2620	Skidtube, 206 Skidtube	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2620 Bent Tube 3" OD <u>B44502</u> <u>D</u> <u>M 9-1-26</u>			
3.0	D32861	Doubler	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3286-1 Doubler <u>B44502</u> <u>44286</u> <u>(2)</u> <u>M 9-1-27</u>			
4.0	D2647	Cap	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2647 Fwd Cap <u>B43846</u> <u>BE</u> <u>09/01/26</u>			
5.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
			
Comment: LANDING GEAR RESOURCE 1 1-Deburr Fwd edge of tube <u>M 9-1-26</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 26/01/2009 11:46:00 AM  
User: Julie Dawson

## Process Sheet

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Job Number: 45234A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

*M 9-1-26*

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod *m110295/m109213 BE 9-1-26*

4-Grind weld flush to cap on top surface only.

*BE 9-1-26*

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D2650

15-C'sink GHW rivet holes as per Dwg D2650

*MB  
09-01-27*

*H  
9-1-27*

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*S09/01/27 (XO)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D206642241

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Seq. #: Machine Or Operation: Description :

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to Ø0.3125"

2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6.

3-Deburr tube and blow out chips from inside the tube

Handwritten: H 9-1-29

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: H 9-1-30

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: BE 9-1-30

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

Handwritten: 9-1-31

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Handwritten: # holes are between 0.005" to 0.010" from edge

Handwritten: 507/02/02

12.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number

Description Batch

52 CR3212-4-04 Rivet

Handwritten: M110372

Handwritten: M110377

Handwritten: H 9-2-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D26543	Web
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:



Qty	Part Number	Description	Batch
1	D2654-3	Web	B45319

Handwritten: D H 9-2-2

14.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 9-2-2 Time: 1:45

Finish Date: 9/2/3 Time: 8:00AM

Handwritten: 9/2/3

Handwritten: H 9-2-2

Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291		M109883
	Sikaflex expire date:		9-2-11

15.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Handwritten: S 09/02/03

16.0	D2649	Cross Bolt Spacer
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Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
18	D2649	Crossbolt spacer	B414327

Handwritten: B41364 D H 9-2-2

17.0	D32863	Spacer
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3286-3	Spacer	B43862

Handwritten: BE 09/02/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 45234A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-remove alodine from around hole and prepare for welding

*M 9-2-3*

2-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod *M109213* *8E* *9-2-3*

3-Grind welds flush as per Dwg D2650. *Pm' 09-02-04*

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod *NONE* *8E- 09/02/04*

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Debur

*DP 9-2-4*

19.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets *M110625*

*DP 9-2-4*

20.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivet

batch: *M110139*

*DP 9-2-4*

21.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041 Nut Plate *B34599*

*DP 9-2-4*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D206642241

Job Number:



Seq. #: Machine Or Operation: Description :

22.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

DD 9-2-4

23.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

S 09/02/05 / PD 09-02-05

24.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/05 (X)

25.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

FL 09/02/06 (1)

26.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

M 109996.

START TIME:

13:30

OVEN TEMPERATURE:

320°

FINISH TIME:

14:00

FL 09-02-09 (1)

27.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-09 (X)

28.0 D26483 Wearpad



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2648-3

Wearpad

643989

FL 09/02/10 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 45234A

Part Number: D206642241

Job Number:



Seq. #: Machine Or Operation: Description :

29.0 D265613 Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-13 Wearshoe B40897

FL

30.0 D265621 Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-21 Wearshoe B38748

FL

31.0 D265633 Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-33 Wearshoe B20756

FL

32.0 D34291 Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3429-1 Wearpad B45637

FL

33.0 ALS41032130 Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number Description Batch

44 ALS4-1032-130 Inserts M105819 (x18)

or (see QSI 017)

\* M108606 (x26)

FL 09/02/10

(P)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #: Machine Or Operation: Description :

34.0 AN960JD10L Washer



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty Part Number Description Batch  
46 AN960JD10L Washer m109632

FL

35.0 MS27039108 Screw



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty Part Number Description Batch  
46 MS27039-1-08 Screw m110467

FL

36.0 D26511 Plug



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description Batch  
18 D2651-1 Plugs B44342

FL

37.0 D26513 O-Ring



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description Batch  
18 D2651-3 O-Rings B44277

FL

38.0 MS27039406 Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 MS27039-4-06 Screw m109061

FL

39.0 AN960JD416 Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 AN960JD416 Washer m108161

FL 02/02/10 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #: Machine Or Operation: Description :

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

Sikaflex expire date:

m 109883  
09/11

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650 (D2650-3 detail). Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153.

FL  
09/02/10  
①

41.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646

Aft Cap

591435

FL

42.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date:

m 109883  
09/11

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4

Batch: 11100454

09-02-10

FL 09/02/10 ①

43.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09/02/10 ①

44.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/10 ①

W/O:		WORK ORDER CHANGES					
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Seq. #:

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Description :

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206664241 IF APPLICABLE

Location:

PPP Rev:

B 45234

09/02/17 ①

46.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/17

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-02-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

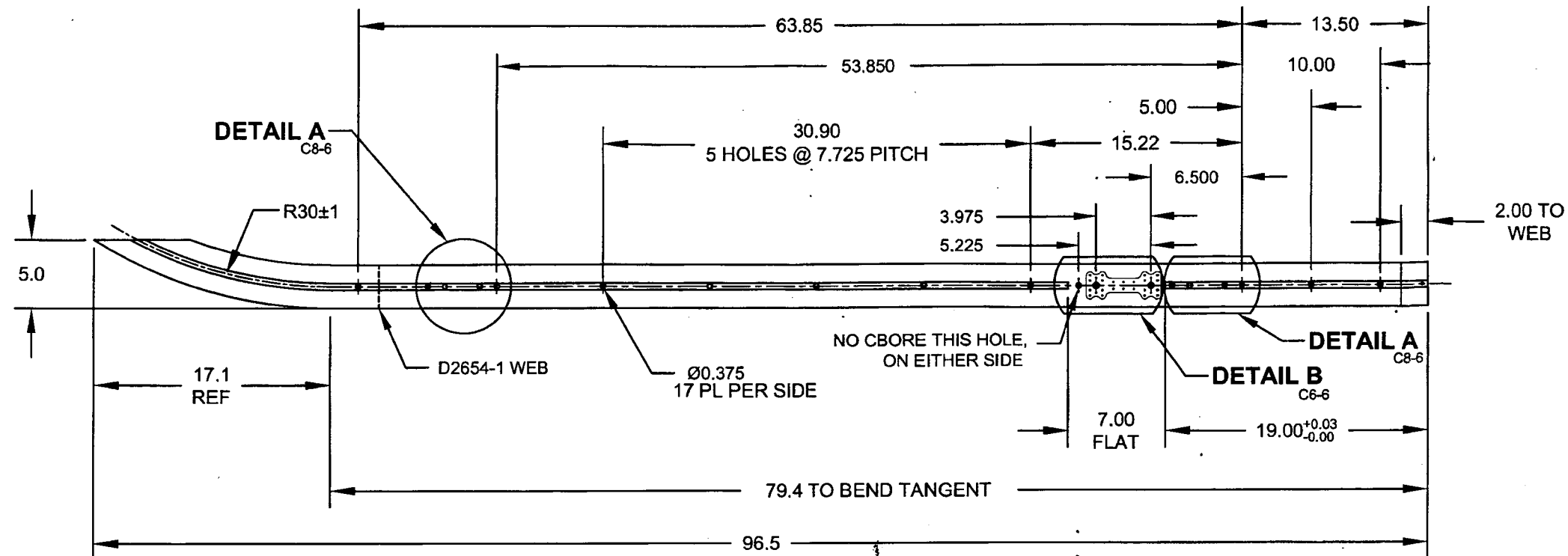
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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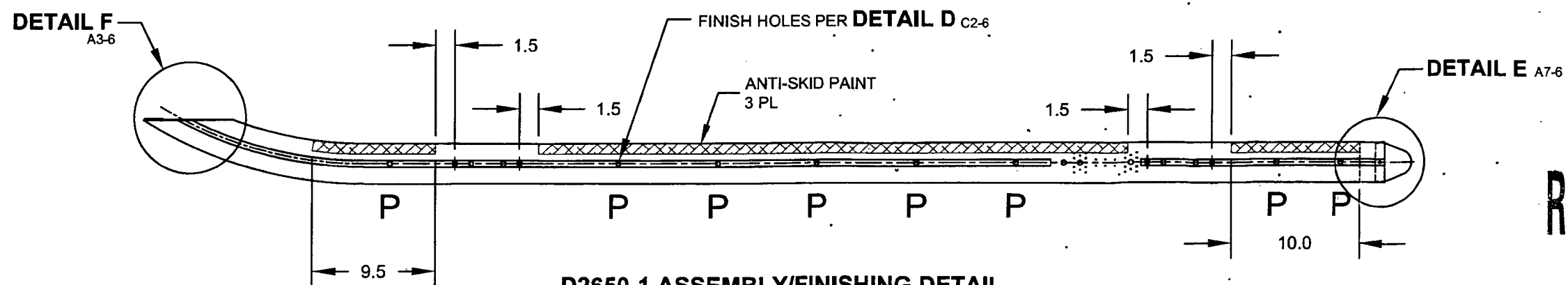
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**D2650-1 BENDING/DRILLING DETAIL**

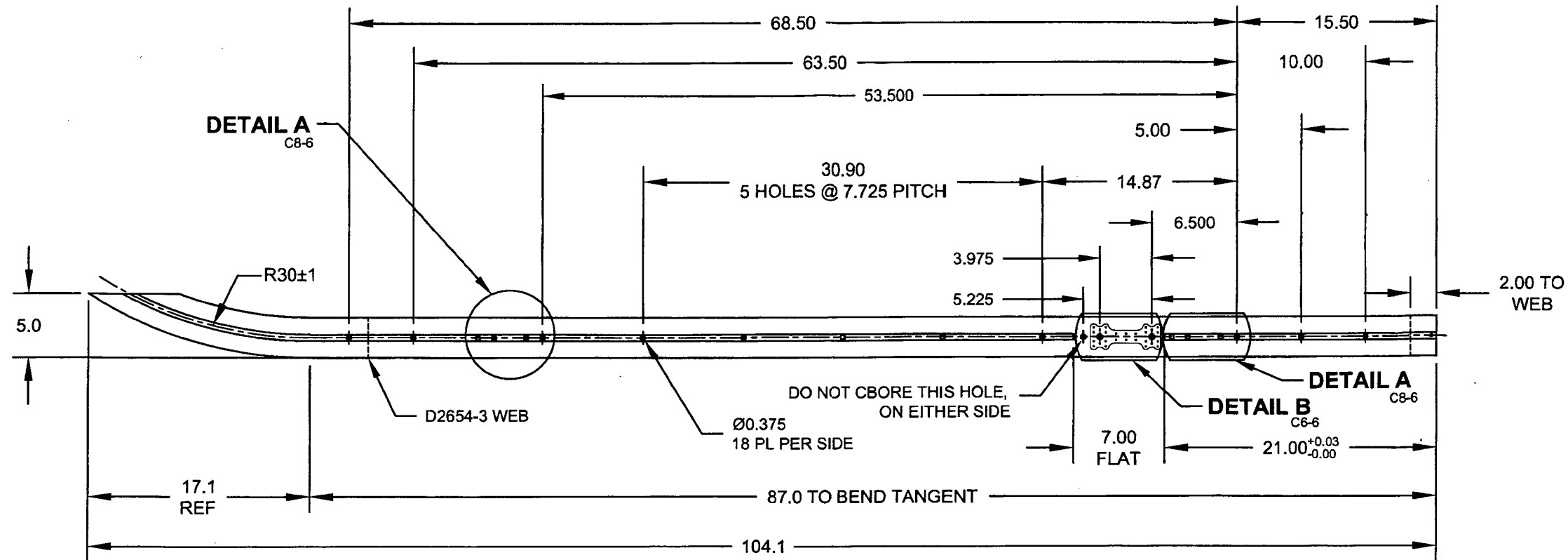


**D2650-1 ASSEMBLY/FINISHING DETAIL**

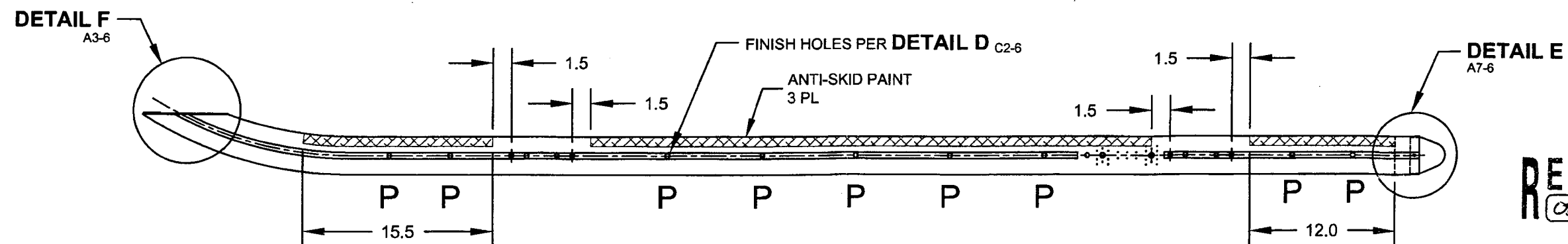
DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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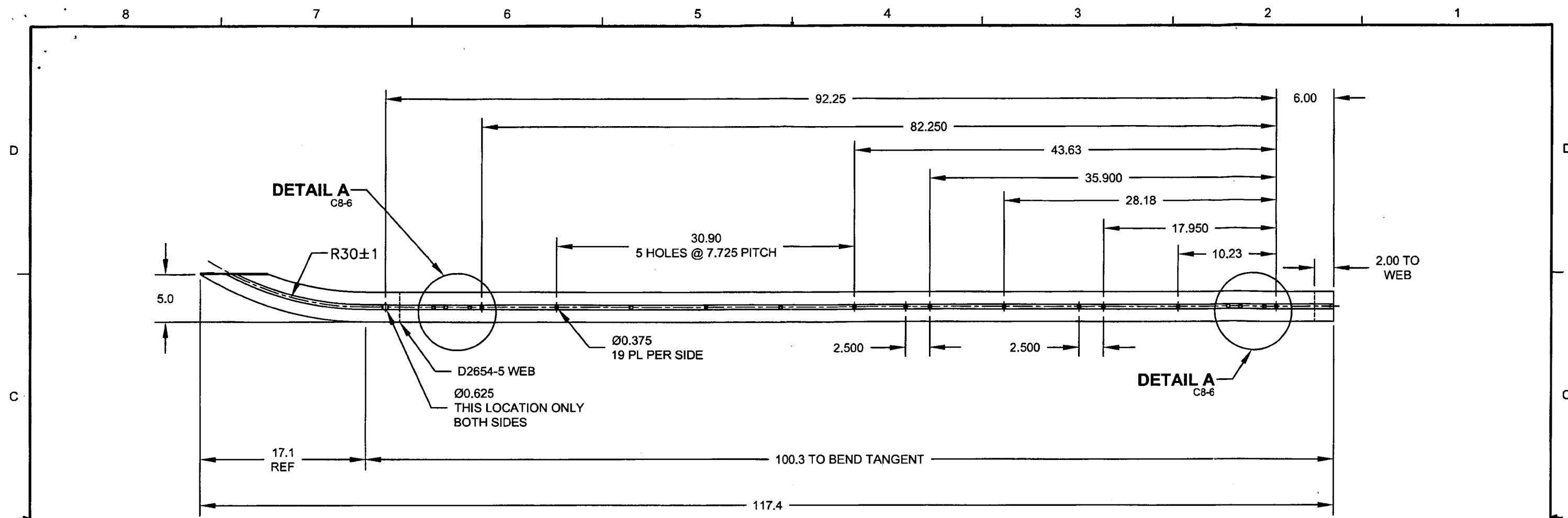


**D2650-3 ASSEMBLY/FINISHING DETAIL**

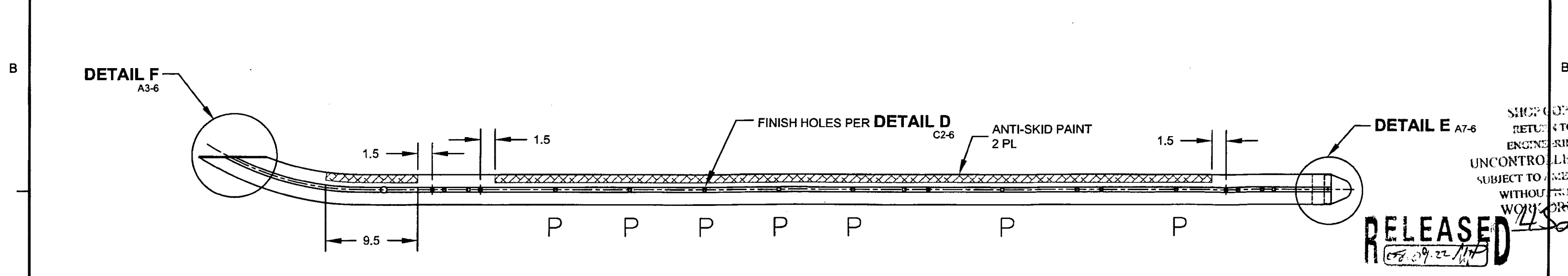
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**D2650-5 BENDING/DRILLING DETAIL**



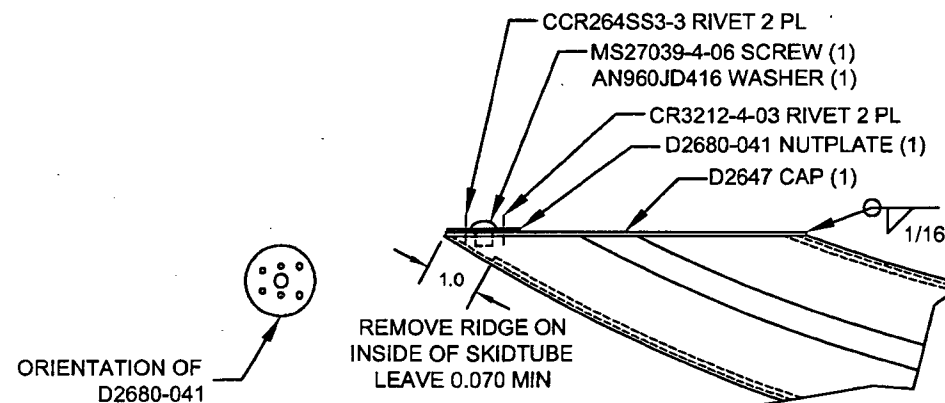
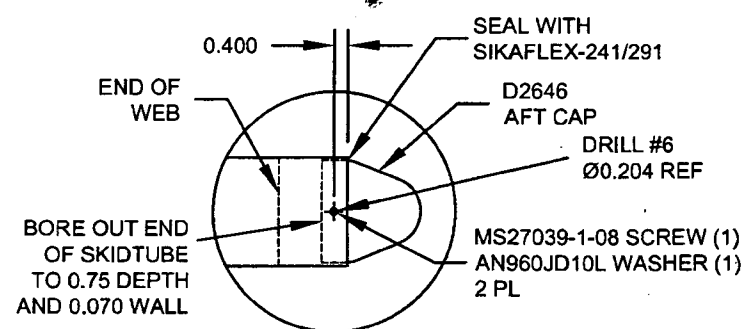
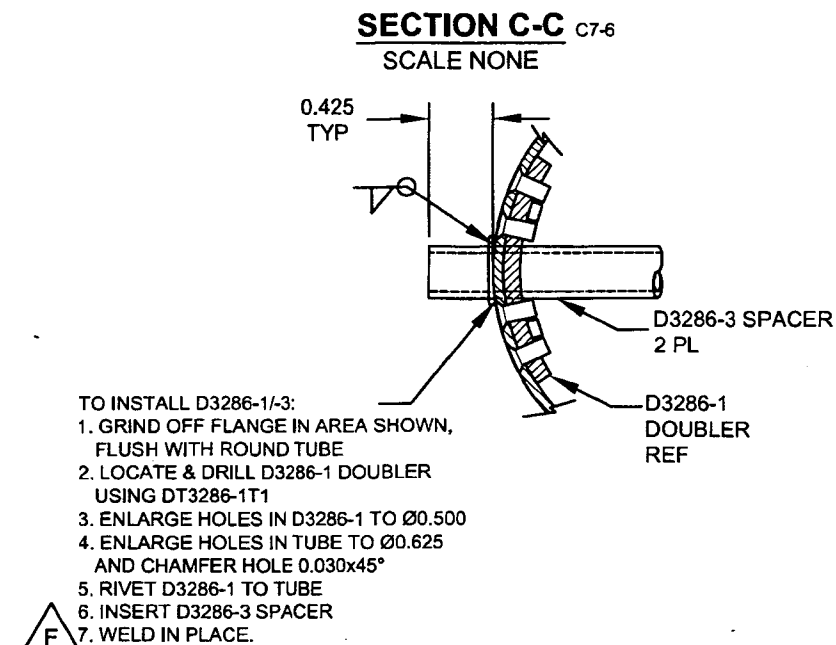
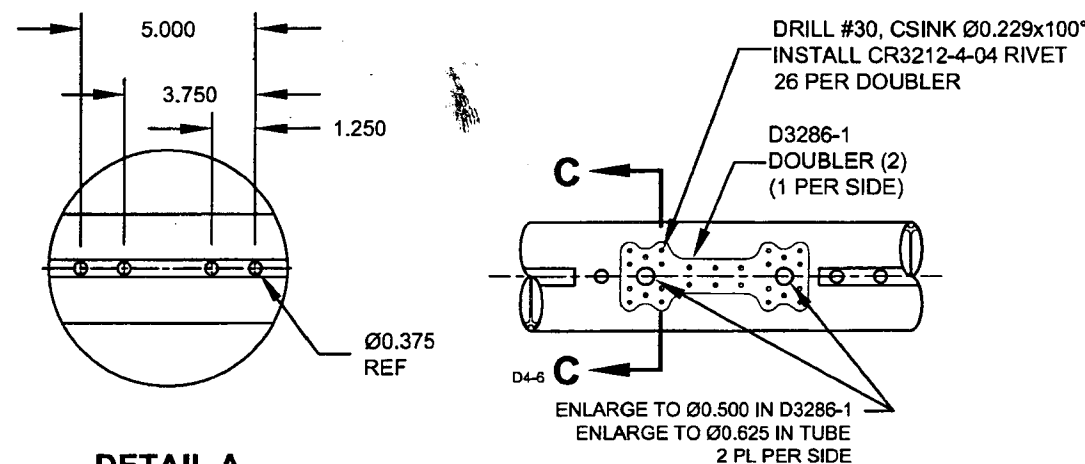
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**DETAIL F NOTES:**

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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NO. 191

**AWS D17.1.2001**  
**QUALIFICATION TEST RECORD**

Name: Berkeley Elliot  
Job number: 45124 A  
Part number: D058 670 041 / 5206 642 241  
Description: 04 58 / 206 skid  
Welding Process: Tig ☒ Mig ☐  
Base material: Aluminium  
Current: AC ☐ DC ☐

**TEST REQUIREMENTS AND RESULTS**

Visual:  
Penetration:

pass ☒ fail ☐  
pass ☒ fail ☐

**UNACCEPTABLE**

Cracks:  
Undercut:  
Pin holes:  
Overlap (cold lap)  
Porosity (surface):  
Coloration:

pass ☒ fail ☐  
pass ☒ fail ☐  
pass ☒ fail ☐  
pass ☒ fail ☐  
pass ☒ fail ☐  
pass ☒ fail ☐

Qualifier P. J. Dyer Date of Test Coupon 9-1-23  
Welder Berkeley Elliot Date of Test Coupon 9-1-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld